

# Work Order ID 59919

June 17, 2010 8:24:40 AM



Page 1

Item ID: D2665-2

Accept



Setup Start



Revision ID:

Item Name: Saddle, RH Fwd Aft Out 206

Stop



Start Date: 18/06/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 30/06/2010 Req'd Qty: 4.00

Customer:

Reference:

*See 18*

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2665

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Program batch number ☐ 2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet ☐ 3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet ☐ 4- Machine Step # 3 of Folio and visually inspect as per attached

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*ref 10.6.26*

*ref 10.6.27*

*ref 10.6.27*

# Work Order ID 59919

June 17, 2010 8:24:41 AM

Page 2

Item ID: D2665-2

Accept

Revision ID:.

Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 18/06/2010 Start Qty: 4.00

Required Date: 30/06/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Setup Start

Stop

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

*S.F 10/06/28*

*4*

*8*

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

*W 10/06/28*

*4*

*8*

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

*M 11/4 841*

Memo

0.00

START TIME:

*2:35*

OVEN TEMPERATURE:

*320°* FINISH TIME:

*3:05*

Powdercoat

Powder Coating

*H*

*BR 10-6-20*

# Work Order ID 59919

June 17, 2010 8:24:41 AM



Page 3

Item ID: D2665-2

Accept



Setup

Start



Revision ID:

Item Name: Saddle, RH Fwd Aft Out 206

Stop



Start Date: 18/06/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 30/06/2010 Req'd Qty: 4.00



Customer:

Reference:

Run

Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

M 10/07/01

4

0

170

Identify as per dwg & Stock Location: 436

0.00



Packaging

Memo

0.00

Packaging

10/7/01 (4)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/01

10/07/01

# Picklist Print

June 17, 2010 8:24:40 AM

Page 1

Work Order ID: 59919

Parent Item: D2665-2

Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 18/06/2010

Required Date: 30/06/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C ☐ 00.11.01 ☐ Removed P/O for Powder Coat - in house process ☐

EC

IPP Rev:D As per Rev D 07-03-19 JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-003

Manufactured

No

100

Each

40.0000

4



Saddle Billet, 7075



Location

Loc Qty

Loc Code

MAT042

40

59196

40

*af 10.6.27*

4

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 59919
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b> D2665-2
<b>Inspection Dwg:</b> D2665 Rev. D		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.121	.121	.121	.121		
B	0.100	0.140		.115	.115	.115	.115		
C	1.125	1.145		1.141	1.142	1.140	1.141		
D	0.615	0.685		.681	.681	.681	.681		
E	0.240	0.260		.246	.246	.246	.246		
F	1.313	1.343		1.322	1.322	1.322	1.322		
G	0.210	0.230		.220	.220	.220	.220		
H	0.100	0.180		.138	.138	.138	.138		
I	2.470	2.510		2.491	2.491	2.491	2.491		
J	1.565	1.585		1.580	1.577	1.575	1.577		
K	0.235	0.240		.239	.239	.239	.239		
L	0.100	0.120		.115	.115	.115	.115		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.249	1.249	1.249	1.249		
Q	2.495	2.505		1.250	1.250	1.250	1.250		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.316	.316	.316	.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.363	1.363	1.363	1.363		
V	0.787	0.807		.796	.796	.796	.796		
W	0.540	0.560		.547	.547	.547	.547		
X	1.674	1.684		1.677	1.677	1.677	1.677		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.920	.920	.920	.920		
AA	0.490	0.510		.505	.505	.505	.505		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

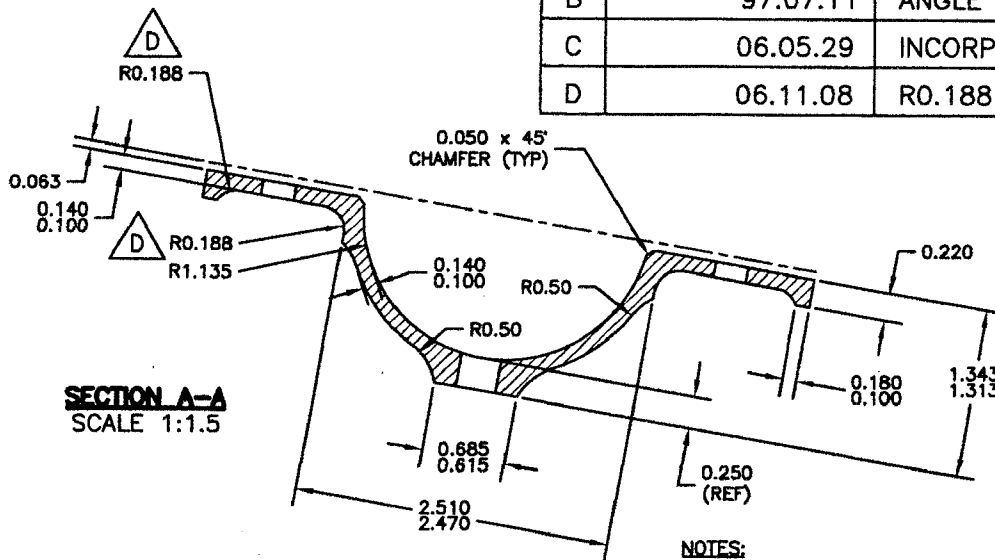
Measured by: <i>MP</i>
Date: 10.6.26

Audited by: <i>AS</i>
Date: 10/06/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	<i>AS</i>

**DART**

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2665	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD OUTSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	



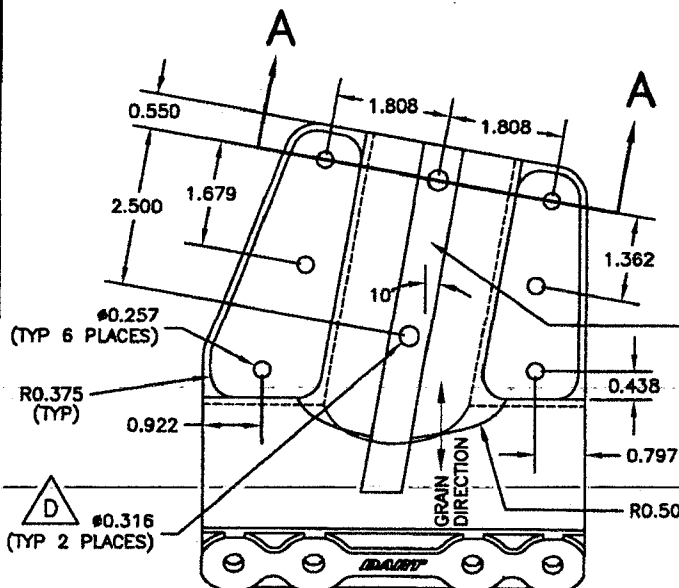
RELEASED

07.02.12 #

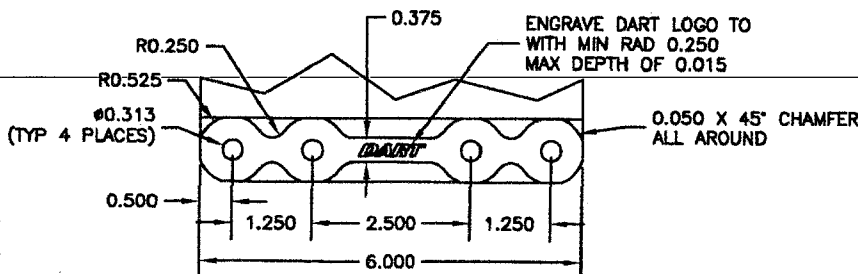
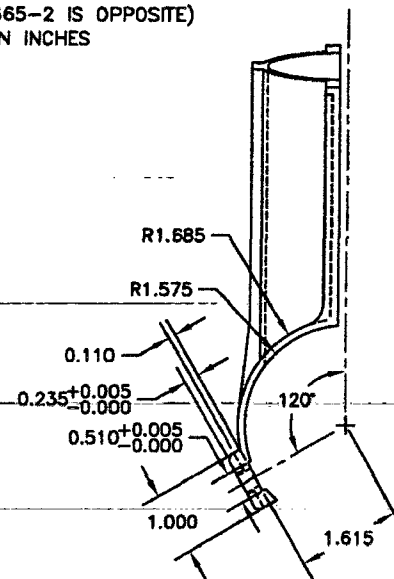
39919

## NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART  
NUMBER AND  
BATCH NUMBER  
TO MAX DEPTH  
OF 0.010 WITH  
MIN RADIUS  
OF 0.010

**D2665-1 SADDLE FWD OUTSIDE HIGH**

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